

Work Order ID 85047

May-31-12 3:40:52 PM

85047

Page 1

Item ID: D4115-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 31/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/06/01* Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4115	B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

304 . 063

Dwg Rev: *13*

Prog Rev:

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-6-18

12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Scrubber

(X)

Quality Control

130

0.00

130

Small Fab

Memo

0.00

8a

Small Fab

1- C'sink holes as per dwg

*EPB
12/06/20*

140

Bend as per dwg

0.00

140

Brake NC

Memo

0.00

(B)

*SB
12/06/20*

Brake NC

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Page 3

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 31/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

8/17/04/20

(X)

Quality Control

160

Identify as per dwg & Stock Location: 098

0.00

160

Packaging

Memo

0.00

8

12/6/20 JB

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

12/6/20 JB

Quality Control

ML5 12/10/20

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Picklist Print

May-31-12 3:40:55 PM

Page 1

Work Order ID: 85047

85047

Parent Item: D4115-5

D4115-5

Parent Item Name: Doubler

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	271.4720	0.3337	2.107579			

M304S16GA

304/316 Sheet .063

**

1312-6-18

Location

Loc Qty

Loc Code

MAT020

271.472

121626

143.972

121889

127.5

121889

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Dart Aerospace Ltd

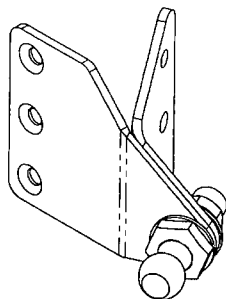
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

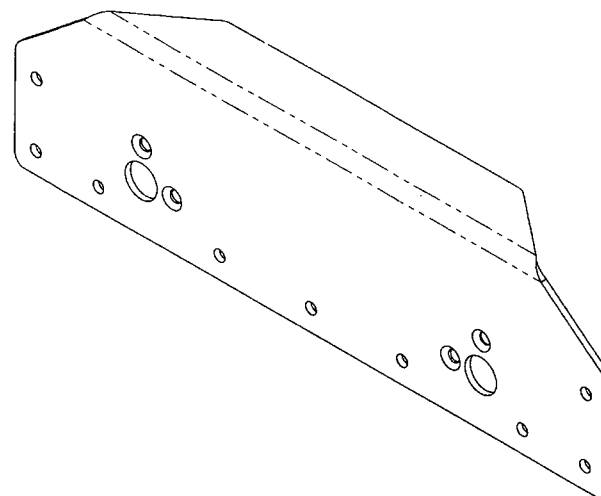
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D4115-041 LITTER DOOR BRACKET ASSY



D4115-5 BRACKET, LITTER DOOR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 05047 MLJ

12/06/01

RELEASED
2010-11-30
MM

B	MATERIAL THK CHANGED FROM 0.063 TO 0.080	JPH	10.11.17
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4115	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LITTER DOOR BRACKET	NTS
DATE	10.11.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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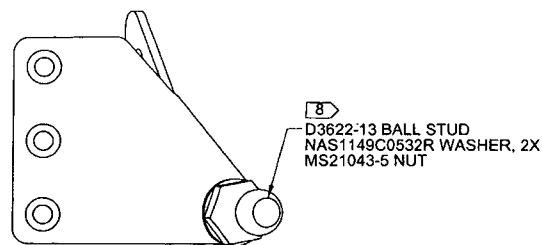
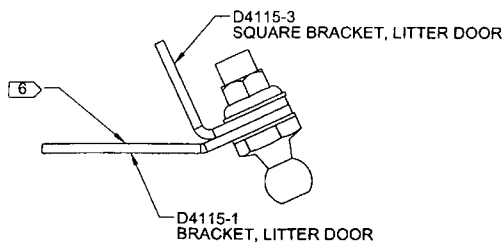
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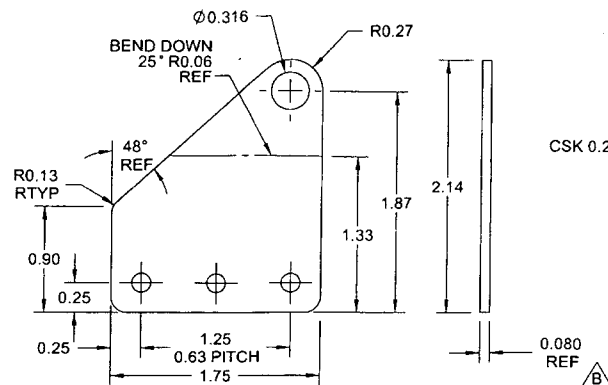
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Qty -041	Part Number	Description
	D4115-041	LITTER DOOR BRACKET ASSY
1	D4115-1	BRACKET, LITTER DOOR
1	D4115-3	SQUARE BRACKET, LITTER DOOR
1	D3622-13	BALL STUD
2	NAS1149C0532R	WASHER
1	MS21043-5	NUT

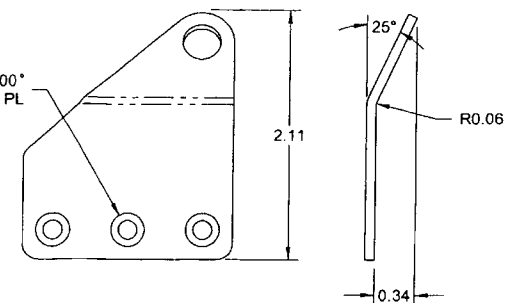


D4115-041 LITTER DOOR BRACKET ASSY

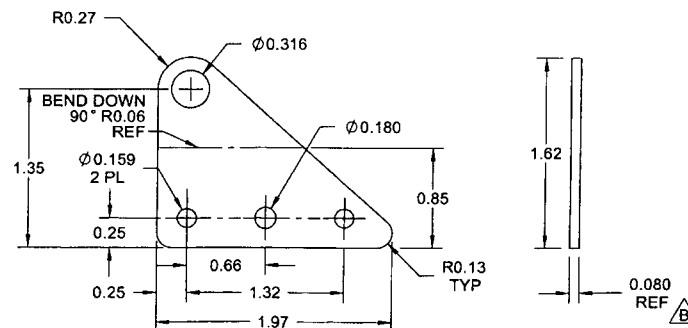


D4115-1F FLAT PATTERN, BRACKET, LITTER DOOR

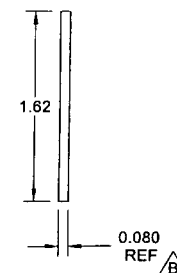
CSK 0.225 X 100°
4 PL



**D4115-1 BRACKET, LITTER DOOR
(MAKE FROM D4115-1F)**



D4115-3F FLAT PATTERN, SQUARE BRACKET, LITTER DOOR



**D4115-3 SQUARE BRACKET, LITTER DOOR
(MAKE FROM D4115-3F)**

NOTES:

- 1) MATERIAL -1F & -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.080 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S14GA OR M303S14GA
-1: MAKE FROM D4115-1F.
-3: MAKE FROM D4115-3F.

- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -041: IDENT P/N D4115-041 & B/N PER QSI 044 6.1
- 7) WEIGHT -041: 0.12 lbs
- 8) TORQUE TO 15 POUND INCH.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4115	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LITTER DOOR BRACKET	NTS
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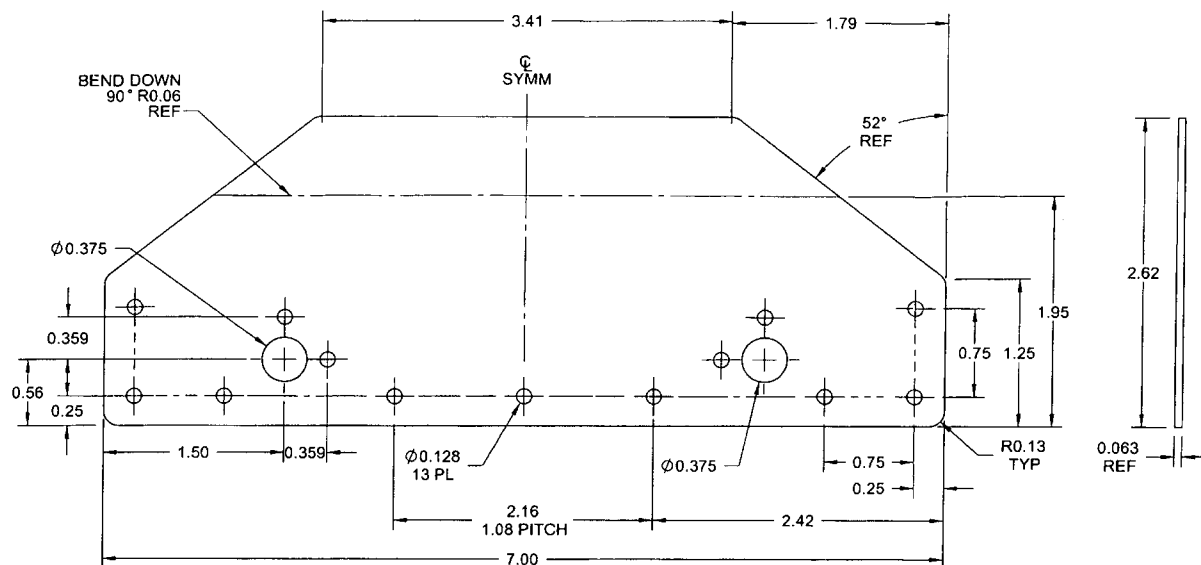
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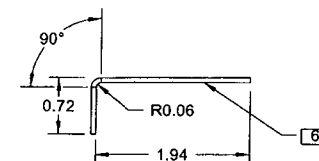
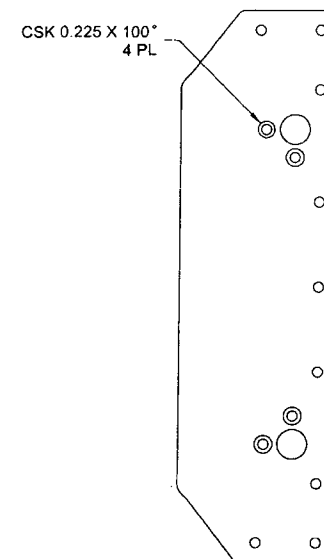
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NOTE: Date & initial all entries



D4115-5F FLAT PATTERN, BRACKET, LITTER DOOR



**D4115-5 BRACKET, LITTER DOOR
(MAKE FROM D4115-5F)**

NOTES:

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-5: MAKE FROM D4115-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -5: IDENT P/N D4115-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.28 lbs

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2010-11-30

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DRAWN	JFH		
CHECKED	JPH	DRAWING NO. D4115	REV. B
MFG. APPR.	JPH		SHEET 3 OF 3
APPROVED	JPH	TITLE LITTER DOOR BRACKET	SCALE NTS
DE APPR.	JPH		
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